

Date: Wednesday, 8/30/2006 10:18:57 AM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INITIAL PROTOTYPE TEMPLATE
Job Number : 00053A	
Estimate Number : 10068	
P.O. Number : N/A	Part Number : INITIAL PROTOTYPE D3523-1
This Issue : 8/30/2006 S.O. No. : N/A	Drawing Number :
Prsht Rev. : NC	Project Number : P604-654
First Issue : 8/24/2006 Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : 00052A	Material : N/A
Written By : <i>E</i>	Due Date : 5/15/2006 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Project #:	
	Description:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 MFG ENGINEERING

MFG ENGINEERING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

- *M6061T6R1.00* batch: *MT81473* (0.110's) *E* 06.08.29- turn as per Dwg D3523 *E* 06.08.30

- QCS

- Acid etch & abrade

- Powder coat Black sandtex (4.3.5.7)

- QC3

PL 06.09.01 ①

E 06.09.01

PRELIMINARY ISSUE

2.0 PG

PURCHASING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

PL 06.09.05 ①

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00053A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3.0

PACKAGING 1

PACKAGING RESOURCE #1



not
required
CB

Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

4.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

ENGINEERING RESOURCE #1

Approval of project manager

PART WENT TO HAI. PART NOT
APPROVED AND NOT AIRWORTHY
CB 07.07.13

5.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

07/07/13

Job Completion



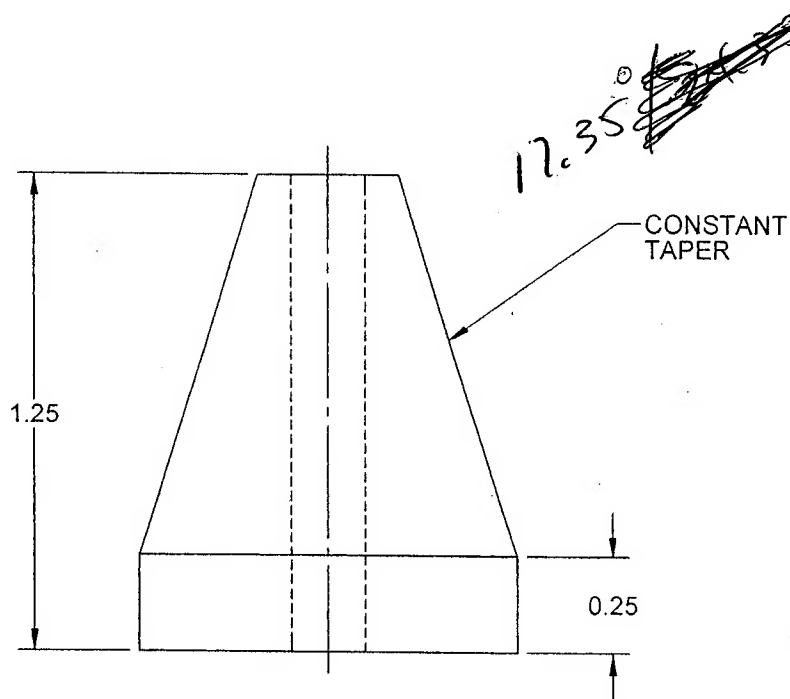
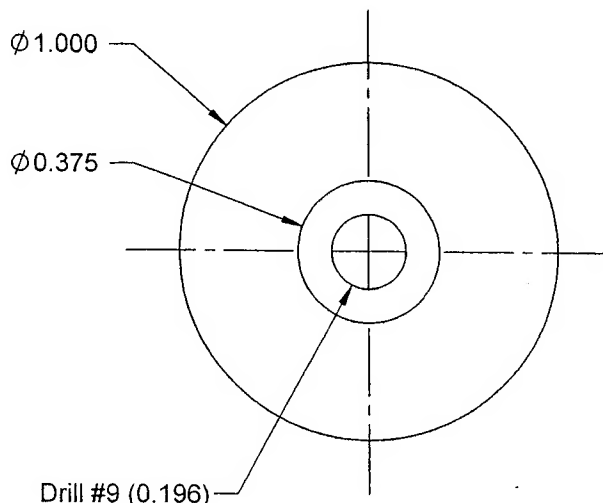
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3523	REV. A SHEET 1 OF 1
DATE 06.05.02		TITLE LEG	SCALE 2:1
A	06.05.02	NEW ISSUE	

UNDER REVIEW

06-08-22 CB

prototype



D3523-1 LEG

NOTES:

- 1) MATERIAL: 6061-T651 ALUMINUM (QQ-A-200/8) $\phi 1.000$ ROUND BAR
(REF. DART SPEC. M6061T6R1.000)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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KAISER ALUMINUM
4111 S 74 E Ave
Tulsa, OK 74145

KAISER ALUMINUM
MATERIAL CERTIFICATION
COPPER & BRASS SALES
6905 KENDERRY GATE UNIT 4
MISSISSAUGA, ON L5T2Y8

PAGE

COPPER & BRASS SALES

SOUTHFIELD

MI 48086 C94583

08/17/04

SOLD TO

PURCHASE ORDER

DATE PRINTED

SOLD TO

PURCHASE ORDER

DATE PRINTED

018542-1

1.000-PRECIS ROD +/- .004 TOL

CUSTOMER PART NUMBER

DESCRIPTION

801378-001

RELEASE-ITEM

503A 206

LOT

6061-T6511B

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT
503A 206	0001 0001	53.8	51.0	11.9		N/A
503A 206	0001 0002	53.5	50.6	11.8		N/A
503A 206	0001 0003	53.6	50.6	11.9		N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Other
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00

118147

APPLICABLE REQUIREMENTS:

PER ASTM-B221-02, STENCILED
ASME-SB221 1998 SECT II
PER AMS-QQ-A-200/8
UNS#6061
MEETS ALL SPECIFICATION
REQUIREMENTS FOR 6061-T6511
ELEVATED MINIMUM MECHANICAL
PROPERTIES AS FOLLOWS:
UTS=42.0 KSI MIN
YIELD=38.0 KSI MIN
ELONGATION=10.0% MIN

Kaiser Aluminum & Chemical Corp. ('Kaiser')
hereby certifies that metal shipped under
this order has been inspected and tested
and found in conformance with the applicable
specifications forming a part of the descrip-
tion set forth in Kaiser's sales acknowledge-
ment form. Any warranty is limited to that
shown on Kaiser's general terms & conditions
of sale. Test reports are on file, subject
to examination.